

Date: Tuesday, 10/02/2009 2:43:38 PM
User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LID PRO ARM ASSEMBLY (SHORT)
Job Number :	45682		
Estimate Number :	10258		
P.O. Number :		Part Number :	D2332041
This Issue :	10/02/2009	Drawing Number :	D2332
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	C
Previous Run :	43721	Material :	
Written By :		Due Date :	28/02/2009
Checked & Approved By :	JUD 09-02-10	Qty:	12 Um: Each
Comment :	Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF Est Rev: C 08-06-02 add comment DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR1000W049	304 RD Tube 1.00 x .049W



Comment: Qty.: 0.4331 f(s)/Unit Total : 5.1975 f(s)
Material: 1.000" OD x 0.049" wall SS Tube (Seamless)
M108756

Batch

EP 09/03/31

2.0	M304R250	304 SS Round bar .250
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Comment: Qty.: 0.1092 f(s)/Unit Total : 1.3104 f(s)
Material: Ø0.250" 304SS Rod
Batch M147931

EP 09/03/30

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

EP 09/03/31 (20)

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2502 f(s)/Unit Total : 15.0024 f(s) 23.753 29.00
304 RD Tube .500 x .035W M110113 M108215 M107967

EP 09/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 09/02/19

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside fo tube and deburr

CP 09/03/30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/31 counter (20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)
***** insure nothing is inside of tube before welding*****

A/R SS Rod Batch: M108775
*****brush weld right after welding, to take color off*****

20K

SP 09.04.01

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.04.01

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/01 counter (20)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble B 9-4-13

2-Assemble as per Dwg D2332

CP 09/04/13 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4-4A	Bolt

Batch

M108138

EP09/04/13

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty	Part Number	Description
3	AN960JD416L	Washer

Batch

M110153

EP09/04/13

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description
1	MS21042L4	Nut (or -4)

Batch

M1109282

EP09/04/13

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13 counter x20

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 312

9/4/13

502

502

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



409-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

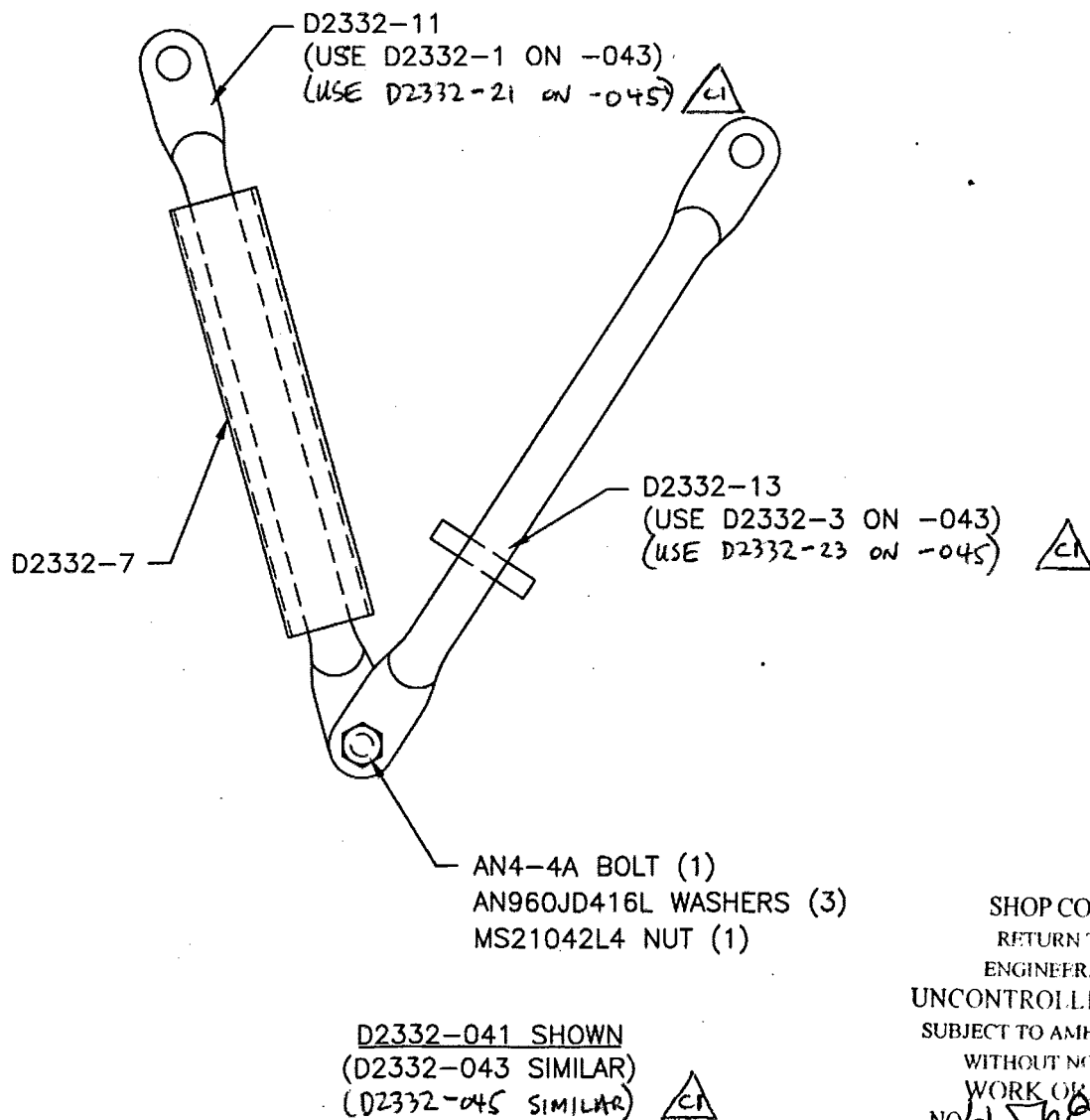
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[Signature]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[Signature]*



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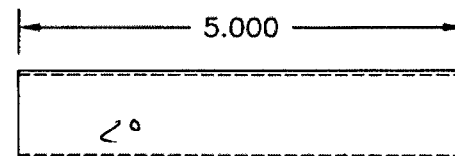
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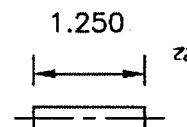
DART



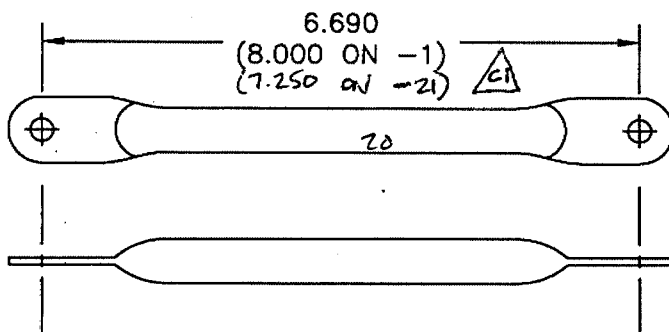
DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		SHEET 2 OF 2	
03.07.03		LID PROP ASSEMBLY		SCALE	
C		03.07.03		MAKE -041 PROP 6.69" LONG (END)	
C1		03.08.06		MAKE -043 PROP 8.00" LONG (INT)	
				ADD -045 PROP 7.25" LONG (6)	



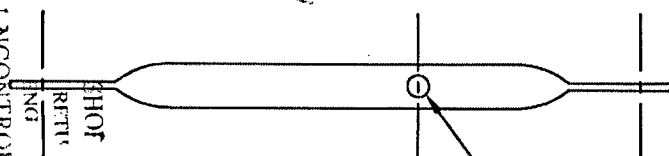
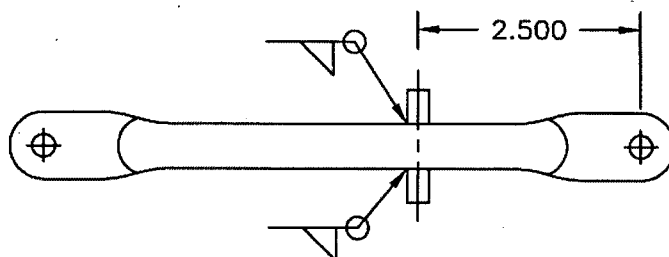
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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